

Work Order ID 77561

77561

Page 1

December-13-11 1:49:39 PM

Item ID: D2230-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Lug
 Start Date: 13/12/2011 Start Qty: 120.00 ***120*** Cust Item ID:
 Required Date: 05/01/2012 Req'd Qty: 120.00 ***120*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/12/13 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2230	Rev G								

100
100 BAND SAW 0.00
 Bandsaw Memo 0.00
 Jeaspa Bandsaw Cut D2423 extrusion to 0.82"
 Batch: 68331
act @ meter
CX 11/12/20

110
110 HAAS CNC VERTICAL MACHINING #1 0.00
 HAAS 1 perch. 0.00
 HAAS CNC vertical machine #1
 Memo
 1-Machine per folio FA927
 FOLIO REV: _____
 DWG REV: _____
 Check for crack while loading into the machine.
 2- deburr
machine as perching D2230 REV.G
P/O: 15701 meter
CX 11/12/20 120

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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120X ~~Q~~ M-L 12/01/19

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Work Order ID 77561

December-13-11 1:49:40 PM

77561

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Item ID: D2230-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Lug

Start Date: 13/12/2011 Start Qty: 120.00

120

Cust Item ID:

Required Date: 05/01/2012 Req'd Qty: 120.00

120

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

120 counted ~~0~~ 12/09/19

170

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

170

Powdercoat

Memo

0.00

Powder Coating

START TIME: 8-40

OVEN TEMPERATURE: 320 °F

FINISH TIME: 9-10

120X ~~0~~ M-12/01/20

180

QC3- Inspect Part Finish

0.00

180

QC

Memo

0.00

Quality Control

120 BL 12-1-20

W/O:		WORK ORDER CHANGES					
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location ST 480	0.00							
190									
Packaging	Memo	0.00							
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00							
Quality Control									

Doc **SP 12-01-23**

12/11/23

MF
12-01-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

December-13-11 1:49:43 PM

Page 1

Work Order ID: 77561

77561

Parent Item: D2230-3

D2230-3

Parent Item Name: Lug

Start Date: 13/12/2011

Required Date: 05/01/2012

Start Qty: 120.00

Required Qty: 120.00

Comments: IPP D00.05.18 Added inspection level 8, and removed P/O for powder coatEC
25 JLM VERIFIED BY:EC IPP REV :E NEW FOLIO # 10-05-

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2230-3P		Purchased	No				Each	0.0000		120			
D2230-3P									**			MF 12-01-23	
LUG													
D2423		Manufactured	No			100	f	411.0900	0.0683	8.627368			
D2423									**			CL 11/12/20	
Lug Extrusion													

Location

Loc Qty

Loc Code

MAT006

411.09

43722

161.5

45800

1

68331

248.59

8.63

B

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

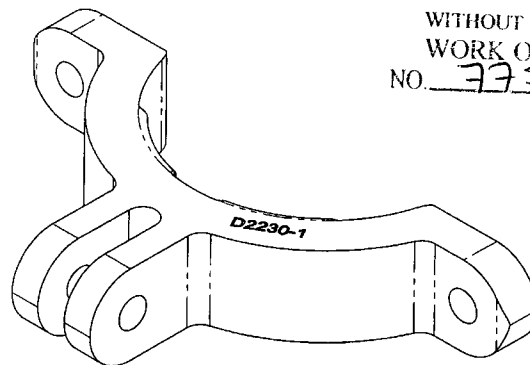
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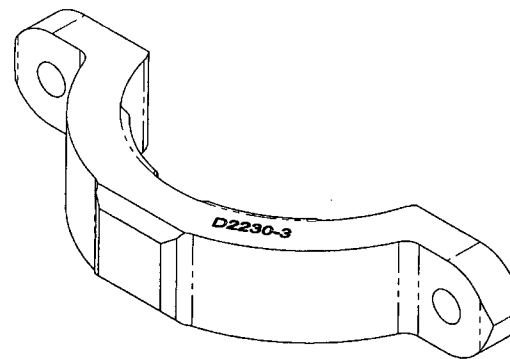
NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 37561 M.L.J
11/12/13



D2230-1 MOUNTING LUG



D2230-3 MOUNTING LUG

RELEASED
09/06/15



NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ± 0.005.
- 7) WEIGHT: -1: 0.16 lbs
-3: 0.14 lbs

G	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION.	AJS	09.01.16
F	REDESIGN: R1.200 WAS 1.100	CP	99.12.13
E	RE-DESIGN	BW	95.01.04
D	RE-DESIGN	BW	95.01.04
C	RE-DESIGN	BW	94.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. G
MFG. APPR.	<i>[Signature]</i>	D2230	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MOUNTING LUG	NTS
DATE	09.01.16	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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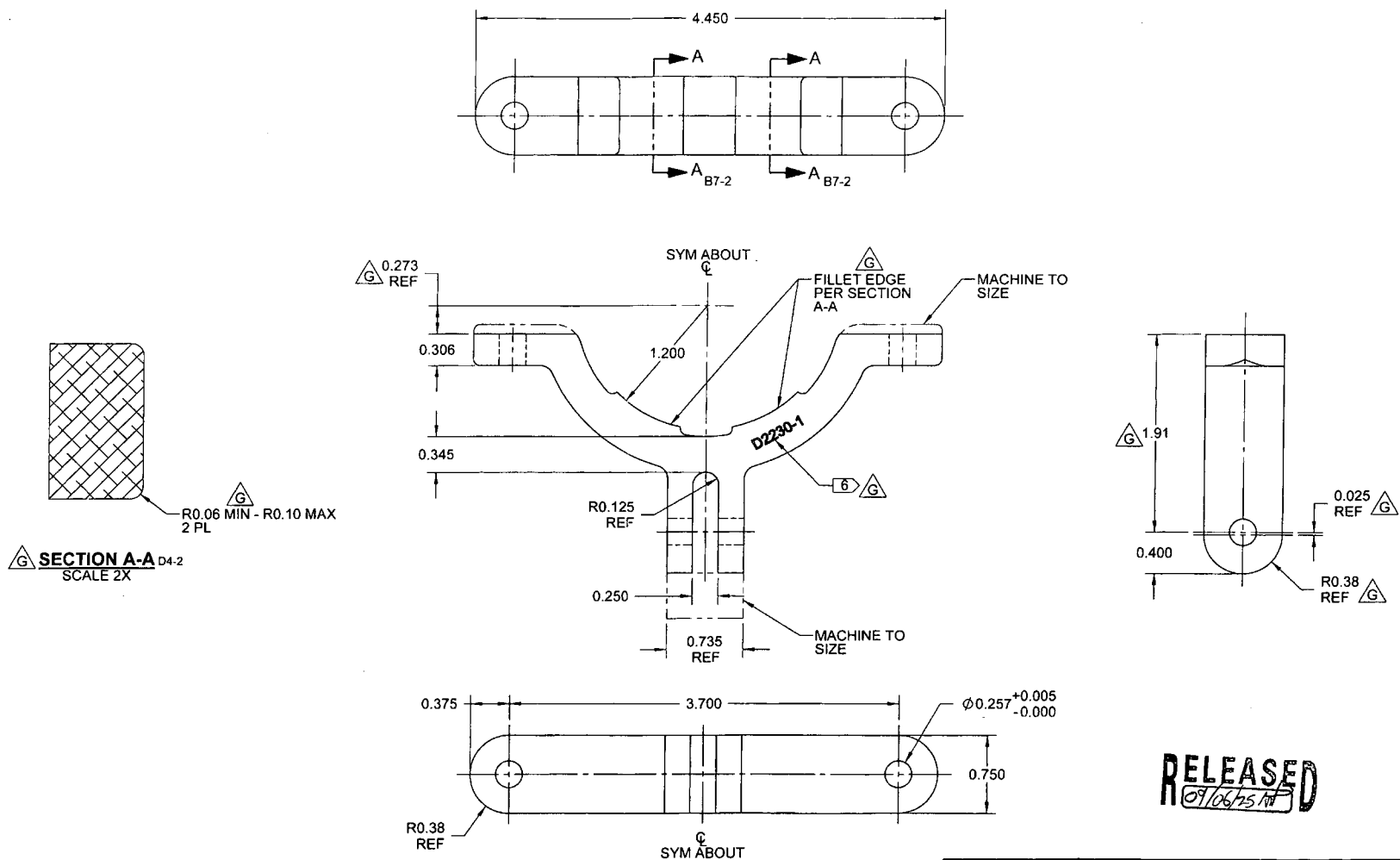
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NOTE: Date & initial all entries

77561



D2230-1 MOUNTING LUG

RELEASED
07/06/95

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D2230	REV. G
MFG. APPR.		TITLE	SHEET 2 OF 3
APPROVED		MOUNTING LUG	SCALE
DE APPR.			NTS
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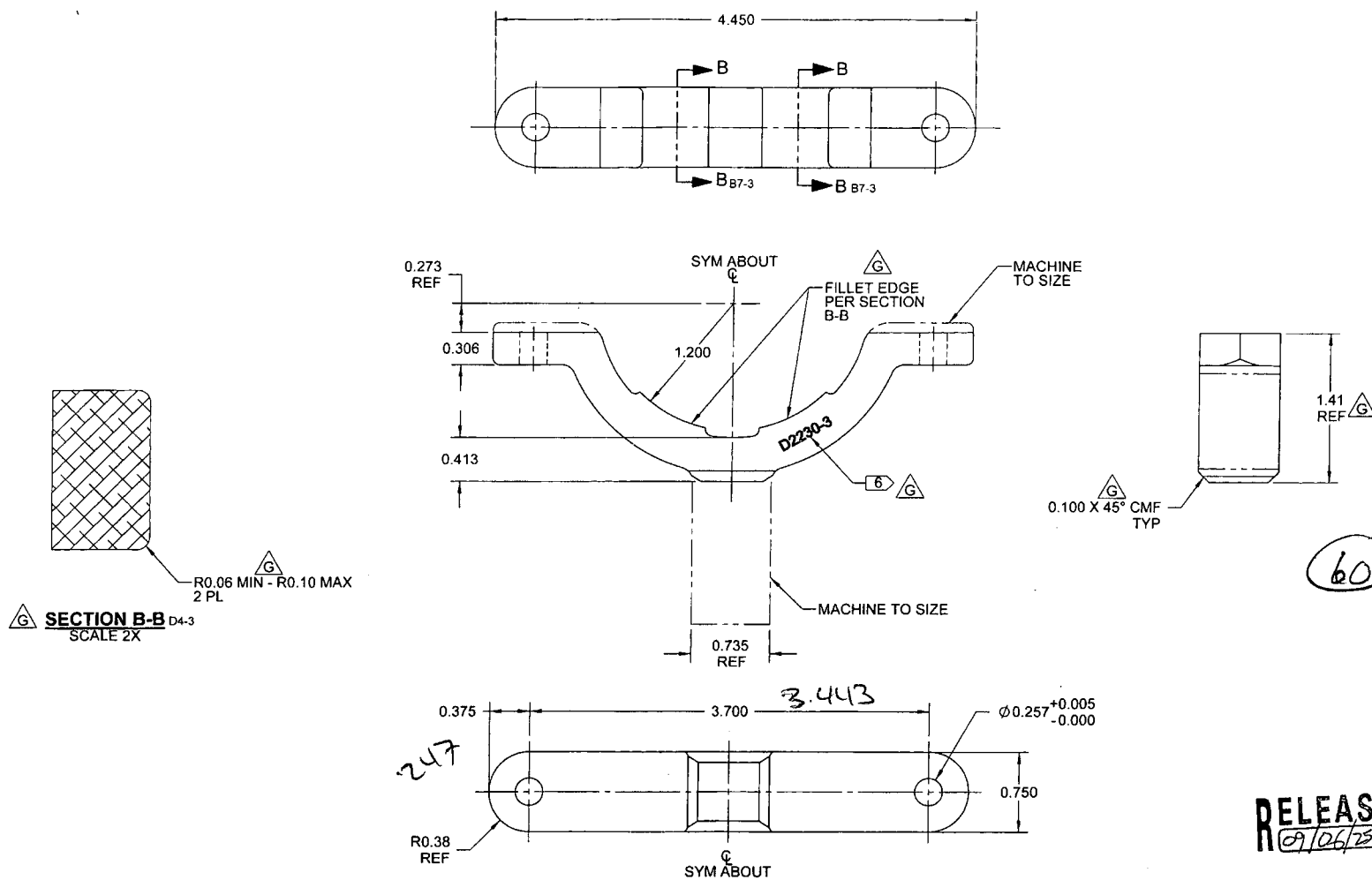
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NOTE: Date & initial all entries

77561



D2230-3 MOUNTING LUG

RELEASED
09/06/2014

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
DATE	09.01.16	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO15701

Purchase Order Date 12/20/11

PO Print Date 12/20/11

Page Number 1 of 1

Order From :

VC-MET003

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, ON K0B 1R0
CA

Contact Name

Vendor Phone 613 678 3957

Vendor Fax 613 678 3956

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr 10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Call 11/12/10

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2230-3P	LUG	1/05/12 Yes	120.00 Each	Dart Truck	\$13.6000	\$1,632.00
		Special Inst:	MACHINE AS PER DWG D2230 REV. G B77561				
2	D3235-1P	lug	1/05/12 Yes	80.00 Each	Dart Truck	\$15.0500	\$1,204.00
		Special Inst:	MACHINE AS PER DWG D3235 REV. A B77566				

PO Total: \$2,836.00

11/20/11 10:00 AM

11/20/11 10:00 AM

Change Nbr: 1

Change Date: 12/20/11

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 18332
Date: Jan 18, 2012
Page: 1

Sold to:	Ship to:
Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: PO15701	Sold By: Dewar, Eric
Shipped By: your truck	Ship Date: Jan 18, 2012

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2230-3 Mounting Lug Machined as per drawing D2230 REVO B77561 Material B68331	Each	120	120	
D3235-1 Mounting Lug Machined as per drawing D3235 REV A B77566 Material B68331	Each	80		80
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				
Received by _____		Thank you for your order!		



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0
Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
120	D2230-3	Mounting Lug	15701
MATERIAL: supplied by DART B68331			

8/2/12

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi Walz

Vankleek Hill, January 18, 2012